

Date  
UserWednesday, 15/08/2007 4:00:32 PM  
Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GAS SPRING  
 Job Number : 33941  
 Estimate Number : 10336  
 P.C. Number : N/A Part Number : D2807  
 This Issue : 15/08/2007 S.O. No. : N/A Drawing Number : D2807 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : C  
 Previous Run : 32774 Material : N/A  
 Written By : W Due Date : 31/08/2007 Qty: 50 Um: Each  
 Checked & Approved By : W  
 Comment : Est: D 05.06.21 Removed painting; Changed supplier  
 KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 4369

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

C 207/08/14  
(50)

2.0

SXF6S6050080S6L115N

GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

SUPPORT PROP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

C 207/08/31 (50)  
PAC-13 (50)  
Inspected each one.

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

D28073

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

D2807-3

Lug

Batch:

B 32001 x 13

33997 x 37

FF 07-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AD Date: 07/11/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:00:32 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 33941

Part Number: D2807

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig.

2-Remove lettering and logo with wash and wipe.

*07/11/22 (50)*

*FF 07-11-22 50  
Counted.*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/11/23 (50) counter*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*back to Sylvie*

*SB 07/11/23 (50)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/11/26*

Job Completion



*07/11/26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

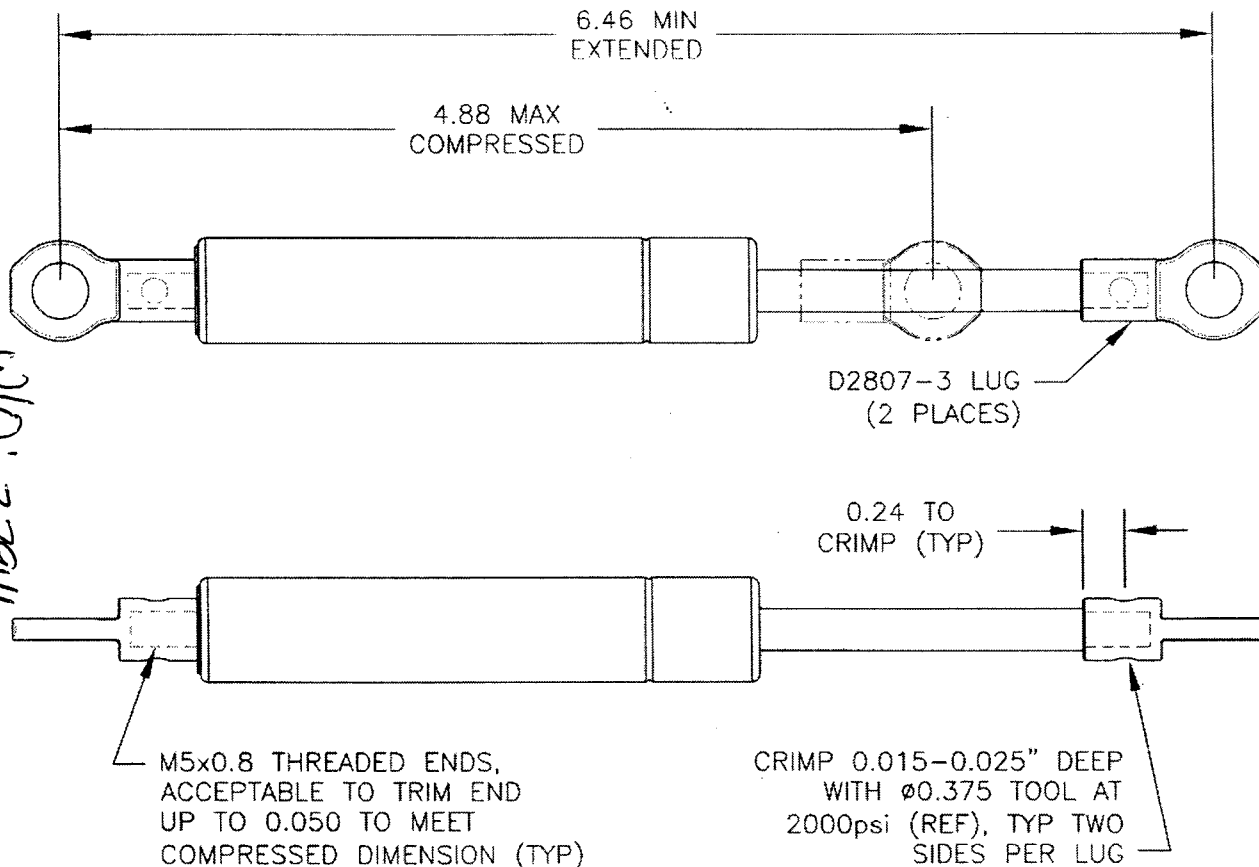
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

RELEASED  
# 05-06-11

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CP	CP	DRAWING NO.	REV. C	
CHECKED	APPROVED	D2807	SHEET 1 OF 2	
DATE		TITLE	SCALE	
05.05.25		GAS SPRING	1:1	
A	00.11.03	NEW ISSUE		
B	05.03.16	ADD FINISH		
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG		



#### D2807 GAS SPRING

- 1) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS

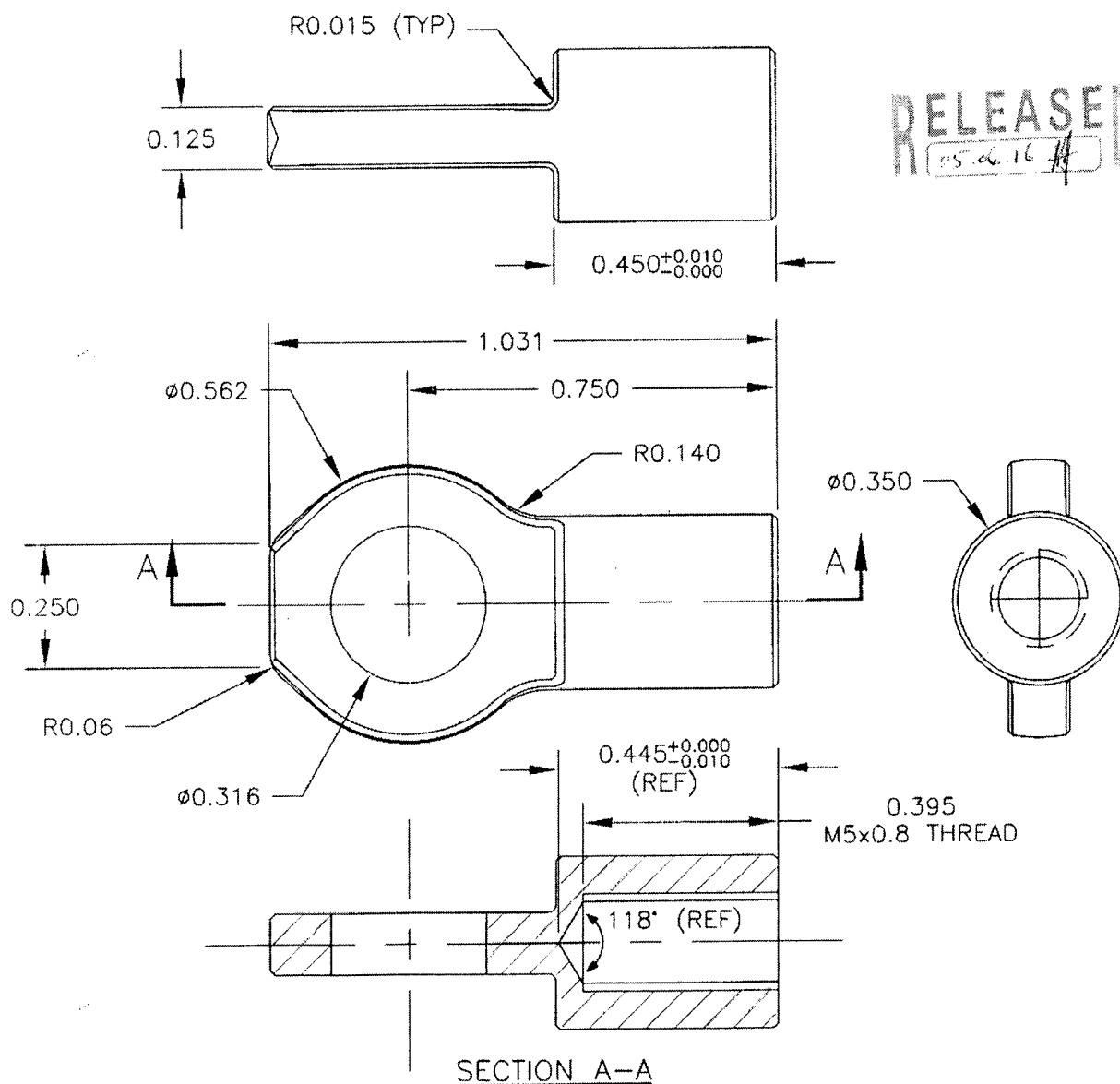
POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/D: 33941



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2807	SHEET 2 OF 2
DATE	TITLE		SCALE
05.05.25	GAS SPRING		3:1



### D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

W/O: 33941

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HAWKESBURY, ONTARIO  
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CANADA

FEDEX ACCOUNT  
15179324-0

2011

FO00004349

V.A.T. REGISTRATION No. GB 738 8577 71

## WORD RECOGNITION

[illegible]

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Certified that the whole of the supplies detailed hereon have been inspected and tested and unless otherwise stated conform in all respects with the contract/purchase order requirements.

SIGNED

POSITION

FED EX  
8572-5756-8201

